

# Work Order ID 52209

September 17, 2009 2:54:15 PM



Page 1

Item ID: D3183-045  
Revision ID: C1  
Item Name: Bearing Assembly

Accept



Setup Start



Stop



Start Date: 9/21/09 Start Qty: 200.00  
Required Date: 9/25/09 Req'd Qty: 200.00  
Reference:



Cust Item ID:  
Customer:

Approvals: Process Plan:  Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start  
Stop



Sequence ID/  
Work Center ID Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn D3183-9 Cap as per Folio FA388. Debur

0.00



0.00

218 

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00



0.00

218 

120



QC

Quality Control


QC8- Inspect parts - second check

Memo

0.00



0.00

218 

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Page 2

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Setup Start



Stop



Start Date: 9/21/09 Start Qty: 200.00  
Required Date: 9/25/09 Req'd Qty: 200.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8/02/02/22

150



Packaging

Packaging

Identify as per dwg & Stock Location: 236A

Memo

0.00

0.00

09/09/22 (218)

counters  
(x218) φ

9-9-20 (218) 32

# Work Order ID 52209

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Item ID: D3183-045  
Revision ID: C1  
Item Name: Bearing Assembly

Accept



Setup Start



Stop



Start Date: 9/21/09 Start Qty: 200.00



Required Date: 9/25/09 Req'd Qty: 200.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/23 *[Signature]*

MF 09-09-22

# Picklist Print

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Page 1

Work Order ID: 52209

Parent Item: D3183-045RevC1

Parent Item Name: Bearing Assembly



Comments:

Start Date: 9/21/09

Required Date: 9/25/09

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3183-5RevC1		Manufactured	No			110	Each	192.0000	200.0000			
												
Bearing												

9/21/09/22  
B52135 (34)

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

192

46853

2

47385

2

47606

2

47675

186

186

MDELNR1.000

Purchased

No

130

f

65.0237

7.0105



Delrin Round Bar 1"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

65.02368421

108757

39.6936842

108804

25.33

10,421 9/21/09

33



**DART**

DESIGN

DRAWN BY

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. C

**D3183**

SHEET 4 OF 4

DATE

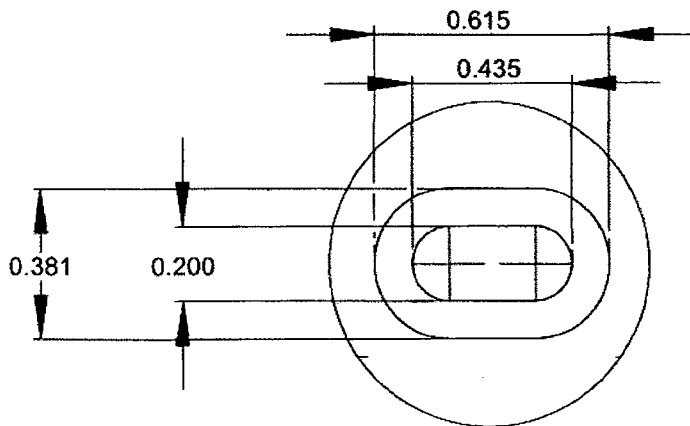
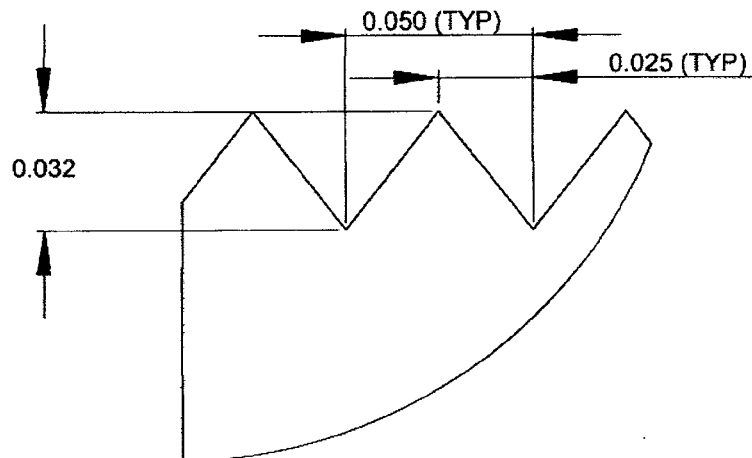
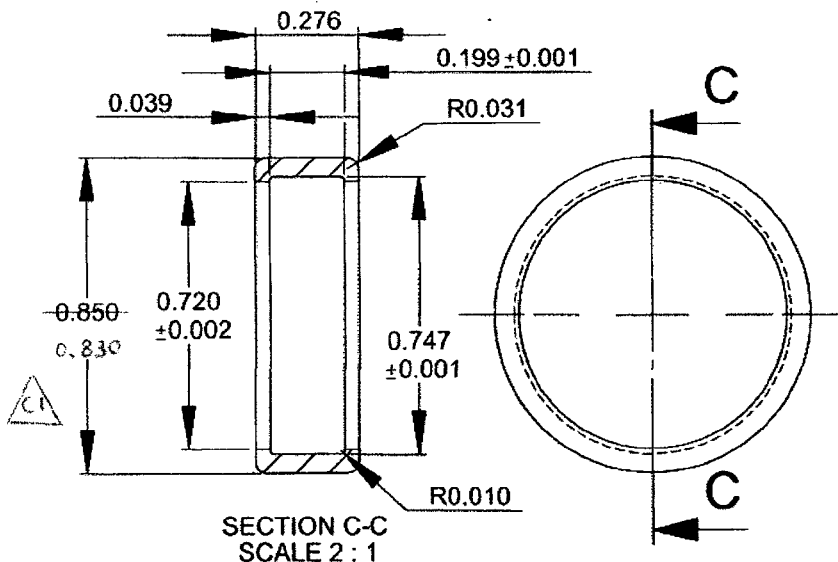
**04.02.17**

TITLE

**BRACKET ASSEMBLY**

SCALE

1:1

**DETAIL A (2 : 1)****RELEASED**  
04.03.01**DETAIL B (20 : 1)***52209***SECTION C-C  
SCALE 2 : 1****D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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